

15/01/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Page 2

Packaging

B. 15/01/16

5 0 DAS
08
9-89

CL15101/22 (5)

5x 5015-01-23

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 127715

127715

Page 3

December-17-14 1:51:28 PM

Item ID: D4802-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 12/17/14 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(5)			DAS 38 9-89 JAN 23 2015
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>54 129</u> Memo	0.00 0.00				DAS 88 9-89			JAN 28 2015
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							15/1/28 JF 15-1-28

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:51:27 PM

Page 1

Work Order ID: 127715

127715

Parent Item: D4802-1

D4802-1

Parent Item Name: Strut

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.500		Purchased	No				f	10.8320		2			
M174PH-H900R0 500									**			15/01/15	DAS 40
17-4SS H900 ROUND BAR 0.500													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT030	8.832	
→ M129892	8.832	
MAT031	2	
M128314	2	

3.75

DQA: _____ Date: _____



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Transport									
Unapproved									

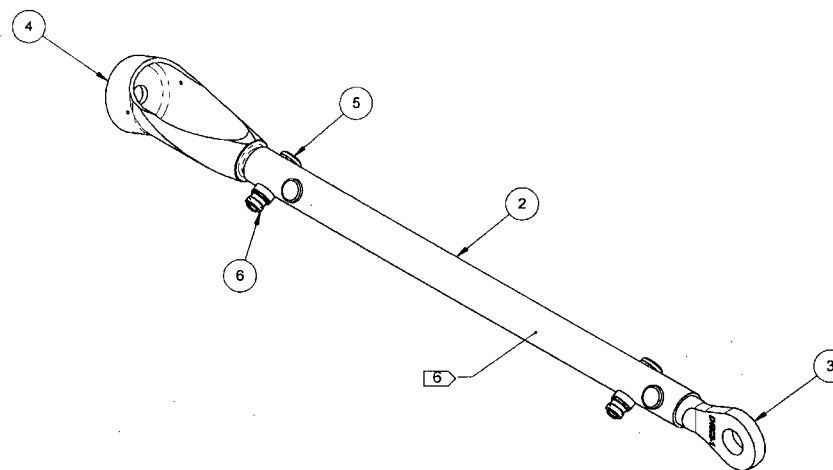
FAULT CATEGORY

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DART AEROSPACE LTD		Work Order:	127715
Description: Strut		Part Number:	D4802-1
Inspection Dwg: D4802	Rev: <i>A C [Signature]</i>		Page 1 of 1

[illegible]

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4802-041	FWD LEG ASSEMBLY
2	1	D4802-1	STRUT
3	1	D4869-1	END FITTING, EYE
4	1	D4920-1	END FITTING
5	4	HL32PB5-8	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4802-041 FWD LEG ASSEMBLY
(EQUIVALENT TO BELL P/N 407-064-106-101)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.46 lbs
- 8) ALIGN PILOT HOLES IN D4802-1 WITH PILOT HOLES IN D4869-1 & D4920-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9953
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9953
- 11) INSTALL HL32PB5-8 HI-LOK IN ORIENTATION SHOWN



PROF COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 127715 MLC
1412-15

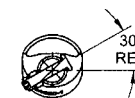
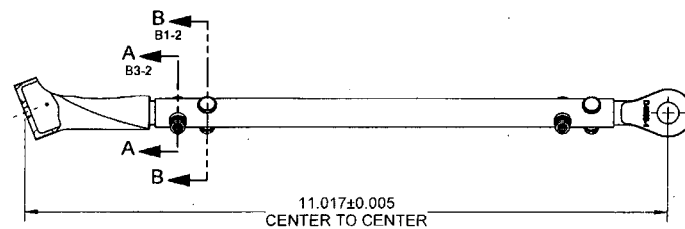
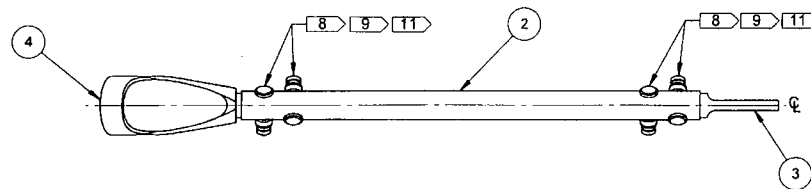
RELEASED
2014-07-07
WJP

C	HL32PB5-8 WAS HL20PB5-8 (ZN D4-1); REVISE NOTE 6)	RF	14.06.24
B	REVISE NOTE 6), 7) & 9) (ZN A8-1); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	14.06.24		

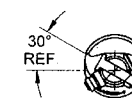
APPROVED

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4802	REV. C
TITLE FWD LEG ASSEMBLY	SCALE NTS
SHEET 1 OF 3	

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SECTION A-A C6-2
2 PL

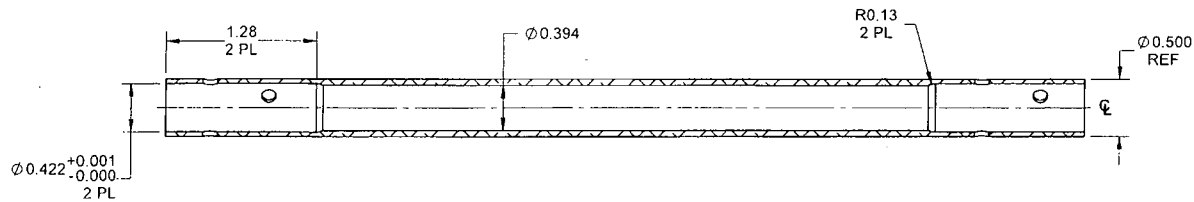


SECTION B-B C6-2
2 PL

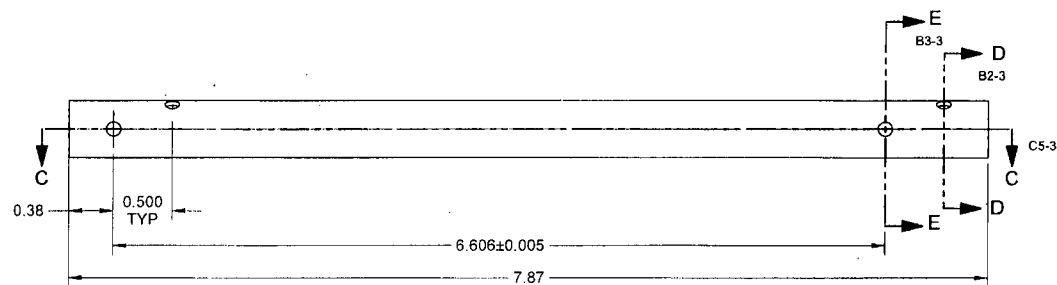
D4802-041 FWD LEG ASSEMBLY
AUXILIARY VIEW

RELEASED
2014-07-07

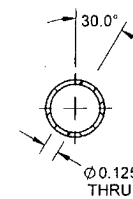
APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4802	SHEET 2 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DSC	FWD LEG ASSEMBLY	NTS
	DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COME OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



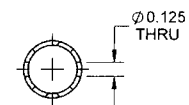
SECTION C-C C3-3



D4802-1 STRUT



SECTION D-D C4-3
2 PL



SECTION E-E C4-3
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.15 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2014-07-07

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4802	SHEET 3 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	D9	FWD LEG ASSEMBLY	NTS
	DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27116

Purchase Order Date 1/19/2015

PO Print Date 1/22/2015

Page Number 3 of 4

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$155.00

71401-45	PROCUREMENT QUALITY CLAUSES	1/19/2015	1.00	\$0.00	\$0.00
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No

1/19/2015

A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A020 NON DESTRUCTIVE TEST/INSPECTION
IDENTIFICATION
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

127715	D4802-1 STRUT	1/19/2015	5.00	\$0.00	\$0.00
--------	---------------	-----------	------	--------	--------

Yes

1/19/2015

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
1 PI AS PER ASTM 1417 LEVEL 2

SP15-01-23

Line Total: \$0.00

Note:

1/22/2015

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23362	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 27116
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 2

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 24 MISC PART:

ID#: D4883-1 END FITING (QTY 11)

1- WORK ORDER ID#: 123070

ID#: D4802-1 STRUT (QTY 5)

2 - WORK ORDER ID#: 127715

ID#: D4837-1 STRUT (QTY 8)

3 - WORK ORDER ID#: 121511

88 15-0121

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-3) AS PER ASTM1417M-13						JAN 20 2015	177mm 8 f
NO CRACK FOUND							
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp 177mm f	Date: JAN 20 2015
Name:			

ANTONINO MARCHETTA